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IS 753 (1983): Handloom Cotton Pugri Cloth, Bleached or Dyed [TXD 8: Handloom and Khadi]

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“Knowledge is such a treasure which cannot be stolen”





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IS : 753 - 1983

*Indian Standard*  
SPECIFICATION FOR  
HANDLOOM COTTON PUGRI CLOTH,  
BLEACHED OR DYED  
( *Second Revision* )

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INDIAN STANDARDS INSTITUTION  
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AMENDMENT NO. 1 JULY 1984

TO

IS:753-1983 SPECIFICATION FOR HANDLOOM COTTON  
PUGRI CLOTH, BLEACHED OR DYED

*(Second Revision)*

Corrigenda

*(First cover, pages 1 and 3, title) - Substitute  
'First' for 'Second'.*

*(Page 7, clause 7.3, line 1) - Delete 'shall be'.*

(TDC 13)

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Reprography Unit, ISI, New Delhi, India

*Indian Standard*  
SPECIFICATION FOR  
HANDLOOM COTTON PUGRI CLOTH,  
BLEACHED OR DYED  
( Second Revision )

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( Continued on page 2 )

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( Continued on page 8 )

*Indian Standard*  
SPECIFICATION FOR  
HANDLOOM COTTON PUGRI CLOTH,  
BLEACHED OR DYED  
( *Second Revision* )

**0. F O R E W O R D**

**0.1** This Indian Standard ( First Revision ) was adopted by the Indian Standards Institution on 10 November 1983, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

**0.2** This standard which was first published in 1955, it has now been revised to make it up-to-date. Important changes carried out in the standard are:

- a) Deletion of breaking strength values, since the standard recommends the use of yarn conforming to IS : 171-1973\*;
- b) Inclusion of pH value; and
- c) Inclusion of inspection, marking and packing clauses.

**0.3** For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

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**1. SCOPE**

**1.1** This standard prescribes the constructional particulars and other requirements of three varieties of handloom cotton pugri cloth, bleached or dyed.

**1.2** This standard does not specify the general appearance, feel, etc of the cloth ( *see also 3.3* ).

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\*Specification for grey cotton yarn ( *second revision* ).

†Rules for rounding off numerical values ( *revised* ).

## 2. MANUFACTURE

**2.1 Yarn** — The cotton yarn used in the manufacture of pugri cloth shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall conform to the requirements of Grade 'C' of IS : 171-1973\*.

**2.2 Cloth** — The cloth shall be free from dressing and filling materials and from substances liable to cause subsequent tendering.

## 3. REQUIREMENTS

**3.1** The constructional particulars of pugri cloth shall conform to those given in Table 1.

**TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON PUGRI CLOTH BLEACHED OR DYED**

VARIETY No.	COUNT OF YARN ( see Note 1 )		ENDS/ cm	PICKS/ cm	MASS g/m <sup>2</sup>	LENGTH m	WIDTH cm	WEAVE
	[ ENGLISH COUNT ( UNIVERSAL COUNT ) ]							
	Warp	West						
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
1.	24s ( 25 tex )	20s ( 30 tex )	24	21	130	4.5 or its multiples	76, 80 or as agreed	Plain
2.	24s ( 25 tex )	24s ( 25 tex )	23	19	110			
3.	30s ( 20 tex )	30s ( 20 tex )	28	22	102	or as agreed		
TOLER- ANCE, PERCENT	—	—	±5	±5	±5	see Note 2	±2	—
METHOD OF TEST				IS : 1963- 1981*	IS : 1964- 1970†	IS : 1954- 1969‡		Visual

NOTE 1 — Count of Yarn is given for guidance only.

NOTE 2 — The length shall be not less than the declared or marked length.

\*Methods for determination of threads per unit length in woven fabrics ( *second revision* ).

†Methods for determination of weight per square metre and weight per linear metre of fabrics ( *first revision* ).

‡Methods for determination of length and width of fabrics ( *first revision* ).

\*Specification for grey cotton yarn ( *second revision* ).

**3.2** The colour fastness ratings and other requirements of the cloth shall conform to those given in Table 2.

**TABLE 2 REQUIREMENTS OF HANDLOOM COTTON PUGRI CLOTH,  
BLEACHED OR DYED**

SL No.	CHARACTERISTICS	REQUIREMENTS	METHOD OF TEST
(1)	(2)	(3)	(4)
i)	Colour fastness rating to:		
a)	Light	5 or better	IS : 686-1957* or IS : 2454-1967†
b)	Washing : Test 4	4 or better	IS : 765-1979‡
c)	Bleaching	4 or better	IS : 762-1956§
d)	Perspiration	4 or better	IS : 971-1983
ii)	Dimensional change, percent, <i>Max</i>	4·0	IS : 2977-1964¶
iii)	Scouring loss, percent, <i>Max</i>	2·5	IS : 1383-1977** ( Mild Method )
iv)	pH value	6·0 to 8·5	IS : 1390-1983†† ( Cold Method )

\*Method for determination of colour fastness of textile materials to daylight.

†Method for determination of colour fastness of textile materials to artificial light (xenon lamp).

‡Method for determination of colour fastness of textile materials to washing: Test 4 (second revision).

§Method for determination of colour fastness of textile materials to hypochlorite bleaching.

||Method for determination of colour fastness of textile materials to perspiration (first revision).

¶Method for determination of dimensional changes of woven fabrics (other than wool) on soaking in water.

\*\*Methods for determination of scouring loss in grey and finished cotton textile materials (first revision).

††Methods for determination of pH value of aqueous extracts of textile materials (first revision).

**3.3** If in order to illustrate or specify the indeterminable characteristics such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**3.3.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

#### **4. INSPECTION**

**4.1** The cloth when visually inspected should be reasonably free from the following defects:

a) Weft crack or more than two missing picks across the width;

- b) Prominently noticeable **weft** bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvedge defects;
- e) Noticeable warp or **weft** float;
- f) Noticeable oil or other stains;
- g) Noticeable hole, cut or tear up to 3 mm in size;
- h) Smash rupturing the texture of the fabric; and
- j) Prominently noticeable dyeing defects ( bars, streaks and patches, etc ).

**4.1.1** A reference may be made to IS : 4125-1967\* for details of these defects.

## 5. MARKING

**5.1** The cloth shall be suitably marked or labelled with the following information:

- a) Name of the material, and variety number;
- b) Manufacturer's name, initials or trade-mark;
- c) Month and year of manufacture; and
- d) Length and width of piece.

**5.1.1** The cloth may also be marked with the ISI Certification Mark.

**NOTE** — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution ( Certification Marks ) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

## 6. PACKING

**6.1** Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS : 1347-1972† or IS : 293-1980‡.

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\*Glossary of terms pertaining to defects in fabrics.

†Specification for inland packaging of cotton cloth and yarn (*first revision*).

‡Code for seaworthy packaging of cotton yarn and cloth (*third revision*).

## 7. SAMPLING

**7.1 Lot** — The quantity of handloom cotton cloth of the same variety, width and colour delivered to a buyer at a time shall constitute a lot.

**7.2** To ascertain the conformity of the lot to the requirements of this standard, samples shall be drawn and inspected from each lot separately.

**7.3** The number of pieces shall be selected at random for inspection shall be in accordance with Table 3.

**TABLE 3 SAMPLE SIZE AND PERMISSIBLE NUMBER OF NON-CONFORMING PIECES**

LOT SIZE	SAMPLE SIZE	PERMISSIBLE NUMBER OF NON-CONFORMING PIECES	SUB-SAMPLE SIZE
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 „ 50	5	0	2
51 „ 150	8	0	3
151 „ 300	13	1	3
301 „ 500	20	1	5
501 „ 1 000	32	2	5
1 001 and above	50	3	8

**7.4** For selection of samples at random from the lot, procedure given in IS : 4905-1968\* may be followed.

### 7.5 Number of Tests and Criteria for Conformity

Ends, picks, mass, length & width, indeterminable characteristics and visual inspection	According to col 2	Number of non-conforming pieces shall not exceed the corresponding number given in col 3.
Dimensional change, colour fastness to washing, bleaching, perspiration, scouring loss and pH value	According to col 4	All the test specimens meet the corresponding requirements
Colour fastness to light	2 for lot sizes of 300 or less and 3 for lot sizes 301 and above	-do-

\*Methods for random sampling.

**IS : 753 - 1983**

( *Continued from page 2* )

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## INTERNATIONAL SYSTEM OF UNITS ( SI UNITS )

### Base Units

QUANTITY	UNIT	SYMBOL
Length	metre	m
Mass	kilogram	kg
Time	second	s
Electric current	ampere	A
Thermodynamic temperature	kelvin	K
Luminous intensity	candela	cd
Amount of substance	mole	mol

### Supplementary Units

QUANTITY	UNIT	SYMBOL
Plane angle	radian	rad
Solid angle	steradian	sr

### Derived Units

QUANTITY	UNIT	SYMBOL	DEFINITION
Force	newton	N	1 N = 1 kg.m/s <sup>2</sup>
Energy	joule	J	1 J = 1 N.m
Power	watt	W	1 W = 1 J/s
Flux	weber	Wb	1 Wb = 1 V.s
Flux density	tesla	T	1 T = 1 Wb/m <sup>2</sup>
Frequency	hertz	Hz	1 Hz = 1 c/s (s <sup>-1</sup> )
Electric conductance	siemen	S	1 S = 1 A/V
Electromotive force	volt	V	1 V = 1 W/A
Pressure, stress	pascal	Pa	1 Pa = 1 N/m <sup>2</sup>

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